

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68866



Page 2

Thursday, April 21, 2011 12:43:34 PM

Item ID: D3774-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Seat Back, LH/RH					
Start Date: 4/21/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 5/6/2011	Req'd Qty: 2.00		Customer:		
Reference:					
Approvals: Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start
QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 HandThermo Hand Finishing Thermoforming	Dry Material Memo Dry Sheet as per QSI022 POLYCARBONATE Temp: <u>340°F</u> Time IN: <u>4:30 pm</u> <u>11/04/05</u> Time OUT: <u>7:00 pm</u> <u>11/04/06</u>	0.00 0.00				<u>x2</u>			<u>Dh</u> <u>11/04/26</u>
120 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D32811 and Folio FTA 011 □ Dwg. Rev. <u>B</u> □ Folio Rev. <u>C</u>	0.00 0.00				<u>x2</u>			<u>Dh</u> <u>11/04/26</u>
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>x2</u>			<u>Dh</u> <u>11/04/26</u>

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68866



Page 3

Thursday, April 21, 2011 12:43:34 PM

Item ID: D3774-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Seat Back, LH/RH					
Start Date: 4/21/2011	Start Qty: 2.00		Cust Item ID:		
Required Date: 5/6/2011	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				x2			DL 11/04/26
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				x2			DL 11/04/27
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sulowitz		(x2)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68866

Thursday, April 21, 2011 12:43:34 PM



Page 4

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 4/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location

257

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/21/28

ME
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 12:43:30 PM

Work Order ID: 68866



Parent Item: D3774-3



Parent Item Name: Seat Back, LH/RH

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A New Issue 08.06.04 DL verified by: DD
IPP REV: B Dwg. Update 08.08.19 DL Ipp Rev. C
Add Step 115 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

100

sf

2,384.215

10.667

21.334



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

2384.215789

115261

367

116236

2017.21579

21.334

Wh
11/04/27

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68866
Description: Seat Back		Part Number:	D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:

DL

Date:

11/04/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.37"	✓		VOLUME-C	
33.9	+/-0.100	34.0"	✓		TAPER-D-01	
0.085	Min	0.090"	✓		CAL TH-DT	
0.100	Min	1.10"	✓		CAL TH-DT	
0.100	Min	1.06"	✓		CAL TH-DT	
0.100	Min	1.14"	✓		CAL TH-DT	
0.100	Min	1.11"	✓		CAL TH-DT	
0.100	Min	1.10"	✓		CAL TH-DT	
0.100	Min	1.08"	✓		CAL TH-DT	
0.100	Min	1.05"	✓		CAL TH-DT	
0.100	Min	N/A	DL 11/04/27		N/A	

Measured by:

DL

Date:

11/04/27

Audited by:

DL

Date:

11/04/27

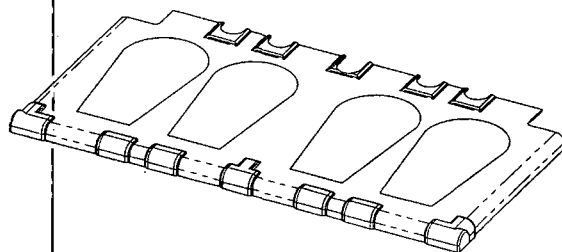
Prototype Approval:

N/A

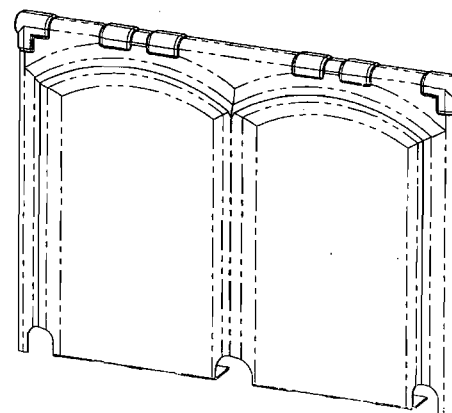
Date:

N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	



D3774-1 SEAT BOTTOM

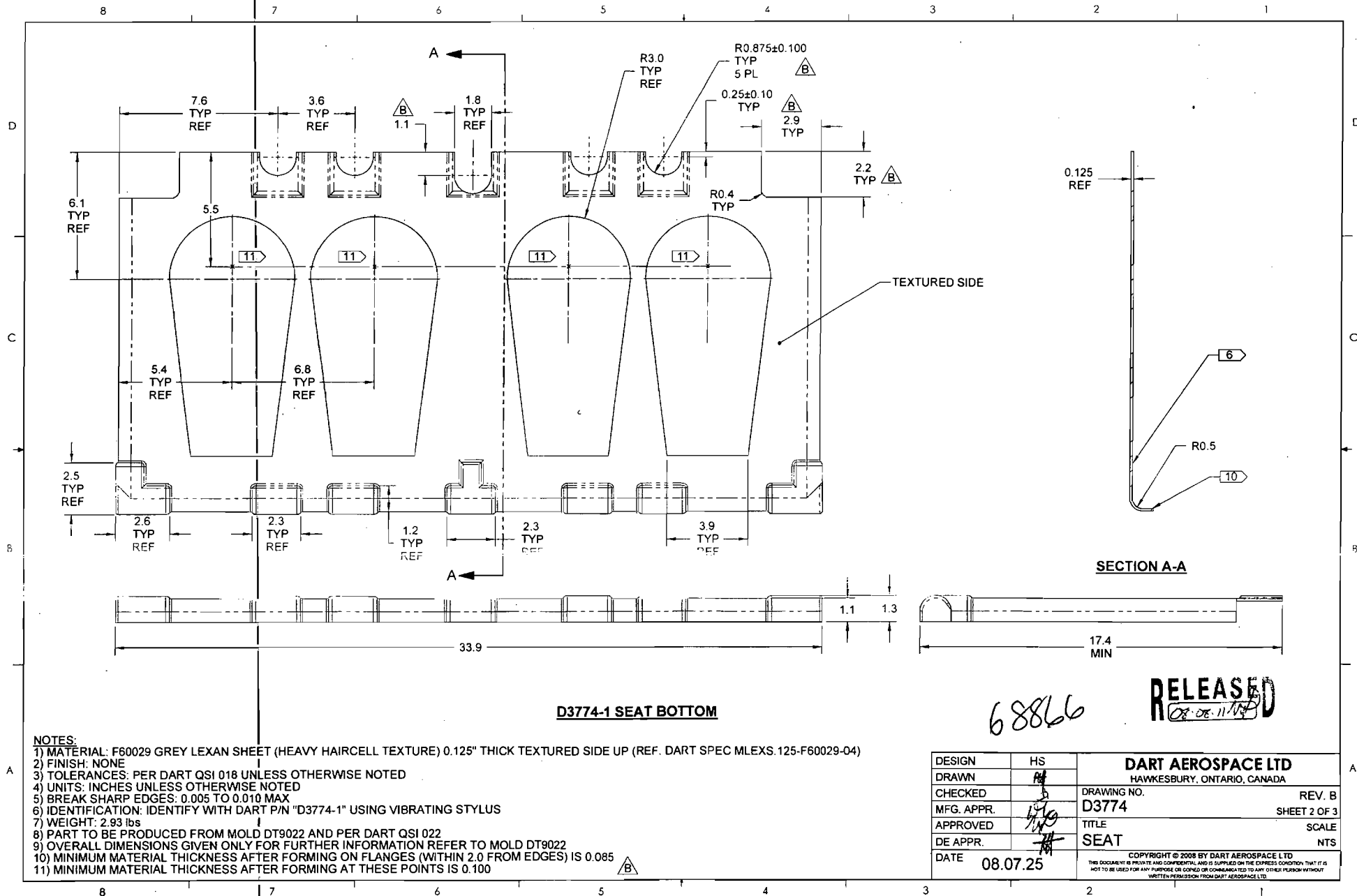


D3774-3 SEAT BACK

RELEASED
08-08-11/11

CL11104/21
WID: 68864

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. D3774	REV. B
CHECKED	PH	SHEET 1 OF 3	SCALE
MFG. APPR.	PH	TITLE SEAT	NTS
APPROVED	PH	DATE 08.07.25	
DE APPR.	PH	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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